

Work Order ID 73230

Friday, August 26, 2011 10:27:49 AM



Page 1

Item ID: D3315-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CD Date: 11/08/26 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3315 | Rev B | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1010.063

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-8-30

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulost3

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 73230

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | NC BRAKE | 0.00 | | | | (4) | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u> | | | | | | | | |
| | 2- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <u>B</u> | | | | | | | | |
| 140 | QC6- Inspect dimensions to drawing | 0.00 | | | | (x4) | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Large Fab | 0.00 | | | | X4 | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: _____ | | | | | | | | |
| | Qty Part Number Description Batch | | | | | | | | |
| | A/R N/A 7560 Hardcoat Rod | | | | | | | | |

11/7964

11-09-07 JRL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

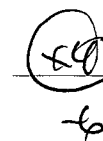
OVEN TEMPERATURE:

FINISH TIME:

3:30
320°F
4:00

0.00

M 117338



4x ✓ m-k 11/09/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 73230

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Page 4

Item ID: D3315-6

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Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

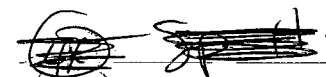
| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 4 | 0 | 20 | u/09/07 |
| 200 Packaging Packaging | Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-6, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location: ST 494 | 0.00 0.00 | | | | | | | |
| 210 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

SP



SP

11-09-08



11/9/08

mf 11-09-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 10:27:47 AM

Page 1

Work Order ID: 73230



Parent Item: D3315-6



Parent Item Name: Wearplate


Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M1010S16GA  | | Purchased | No | | | 100 | sf | 134.3000 | 2 | 8.421053 | | | |

1010/1025 sheet 16GA



B 11-8-30

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

117500

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|-------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 73230 |
| Description: Wearplate | | Part Number: | D3315-6 |
| Inspection Dwg: D3315 | Rev: B | Page 1 of 1 | |



FIRST ARTICLE INSPECTION CHECKLIST

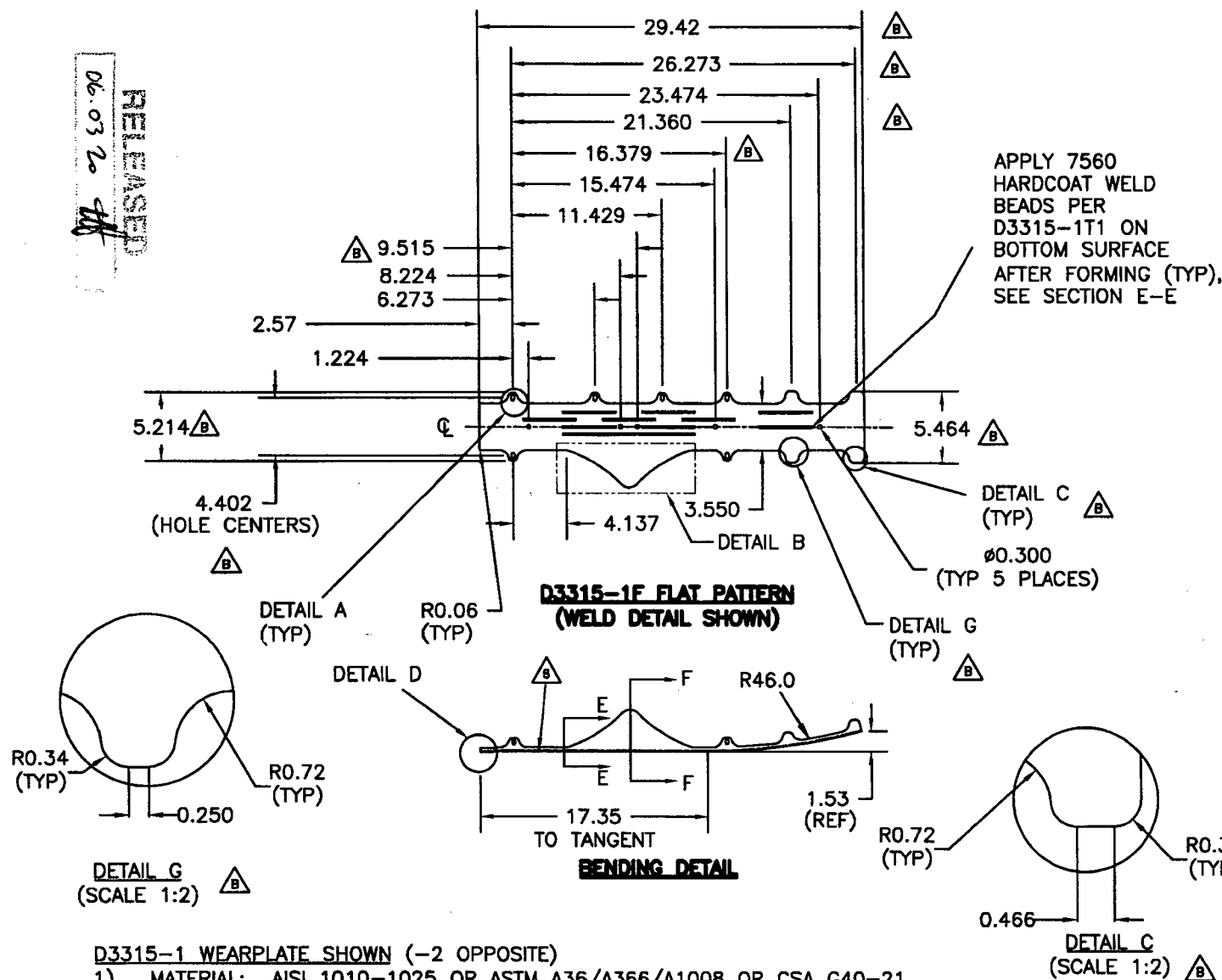
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 34.31 | +/-0.030 | 34.31 | ✓ | | T 1B01 | |
| 30.215 | +/-0.010 | 30.215 | ✓ | | T | |
| 24.215 | +/-0.010 | 24.215 | ✓ | | T | |
| 21.611 | +/-0.010 | 21.611 | ✓ | | T | |
| 17.965 | +/-0.010 | 17.965 | ✓ | | T | |
| 16.026 | +/-0.010 | 16.026 | ✓ | | T | |
| 14.735 | +/-0.010 | 14.735 | x | | T | |
| 12.815 | +/-0.010 | 12.815 | x | | T | |
| 6.465 | +/-0.010 | 6.465 | x | | T | |
| 5.464 | +/-0.010 | 5.467 | ✓ | | V 1B02 | |
| 4.527 | +/-0.010 | 4.522 | x | | V | |
| 3.550 | +/-0.010 | 3.551 | x | | V | |
| 5.214 | +/-0.010 | 5.212 | x | | V | |
| Ø0.300 | +0.006/-0.001 | 0.303 | ✓ | | V | |
| Ø0.266 x 0.575 | +/-0.010 | 266 x 585 | x | | V | |
| Ø0.266 x 0.450 | +/-0.010 | 268 x 455 | x | | V | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
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| | | | | | |
|---------------------|---------|--------------------|----------|----------------------------|-----|
| Measured by: | B | Audited by: | J | Prototype Approval: | N/A |
| Date: | 11-8-30 | Date: | 11/08/31 | Date: | N/A |

| | | | | |
|------------|-------------|---------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | 08.01.22 | New Issue | KJ/EC/DD | [Signature] |

| | | | | | |
|----------|---|-------------------|---|--|--------------|
| DESIGN | 84 | DRAWN BY | 84 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | APPROVED |  | | REV. B |
| DATE | | | TITLE | | SHEET 1 OF 4 |
| 06.01.31 | | | WEARPLATE | | SCALE 1:12 |
| A | 04.09.10 | NEW ISSUE | | | |
| B | 06.01.31 | UPDATE DIMENSIONS | | | |



- D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

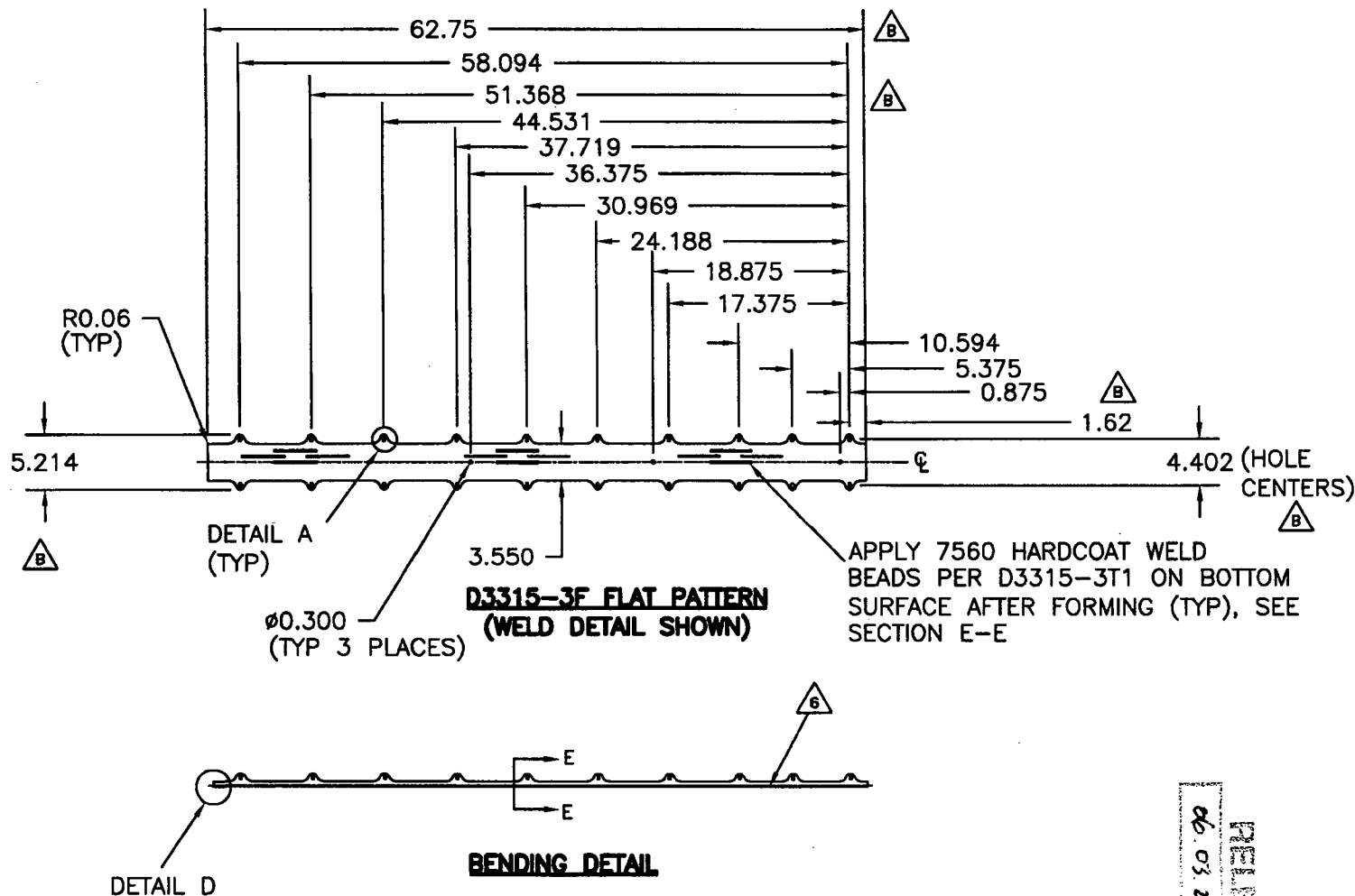
4.3 SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 73230 C L 11/09/26

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DART**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

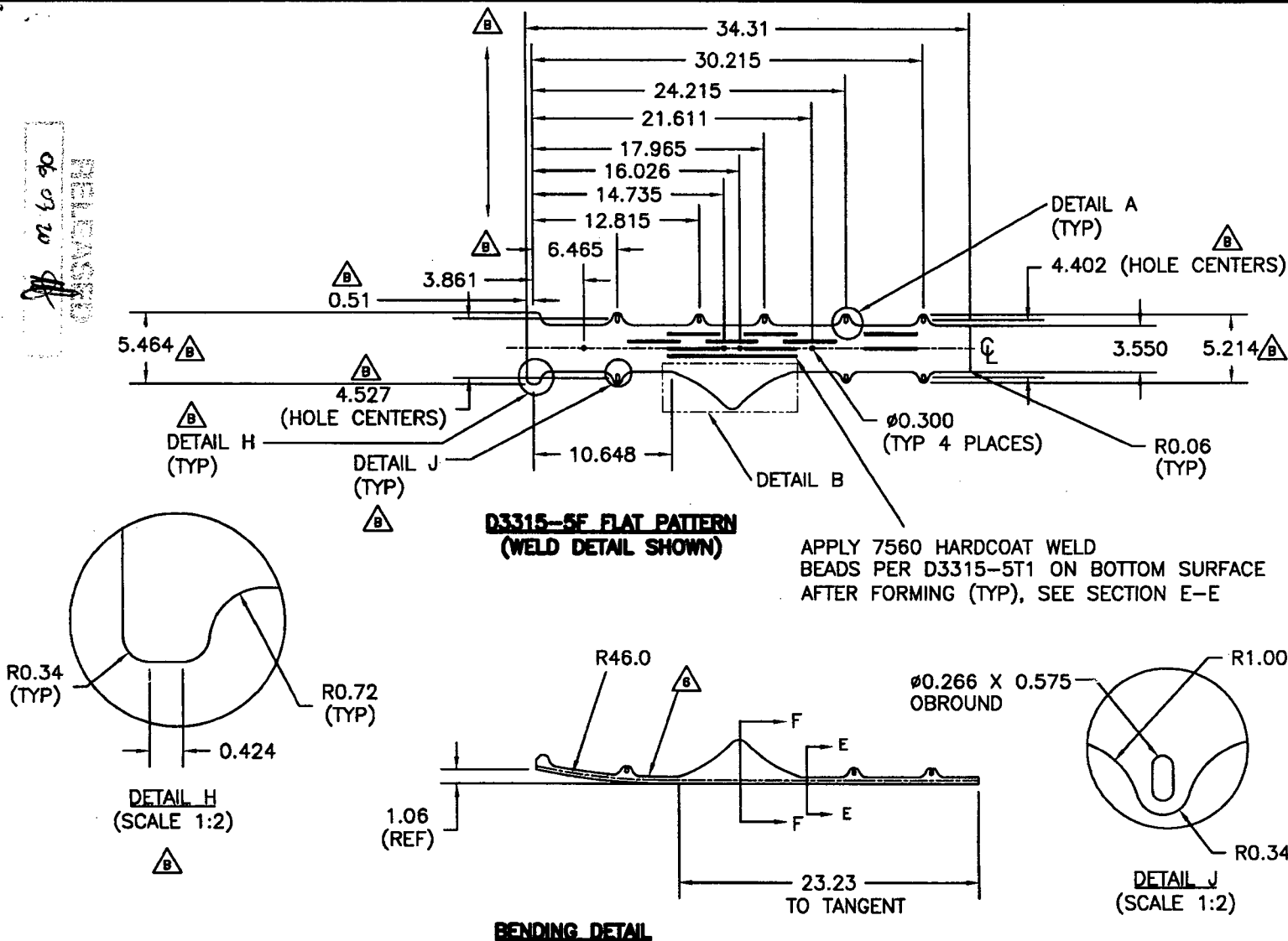
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

| | | | | |
|---------|----------|-----------|-------|-----------------------------|
| DESIGN | 84 | DRAWN BY | 84 | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.01.31 | TITLE | D3315 | REV. B |
| | | WEARPLATE | | SHEET 2 OF 4 |
| | | | | SCALE 1:16 |

RELEASED
06.03.20



| | | | | |
|---------|----------|-----------|-------|-----------------------------|
| DESIGN | 84 | DRAWN BY | 84 | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 06.01.31 | TITLE | D3315 | REVISION |
| | | WEARPLATE | | 1:12 |



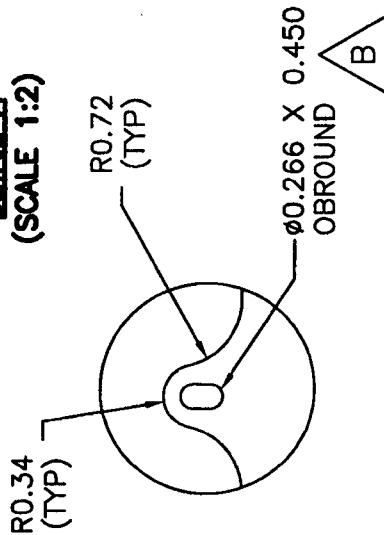
D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3315 | REV. B SHEET 4 OF 4 |
| DATE 06.01.31 | | TITLE WEARPLATE | SCALE NTS |

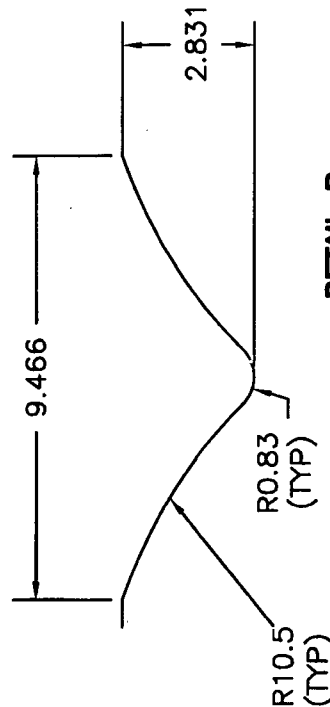
DETAIL A
(SCALE 1:2)



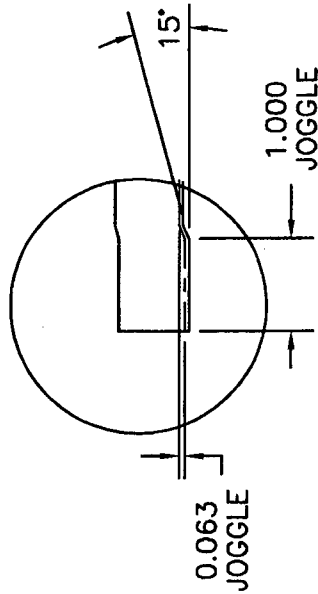
RELEASED

06.03.20

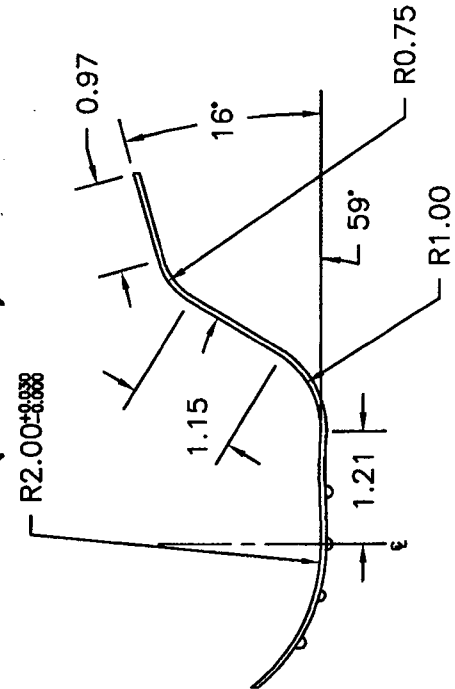
[Signature]



DETAIL B
(SCALE 1:4)

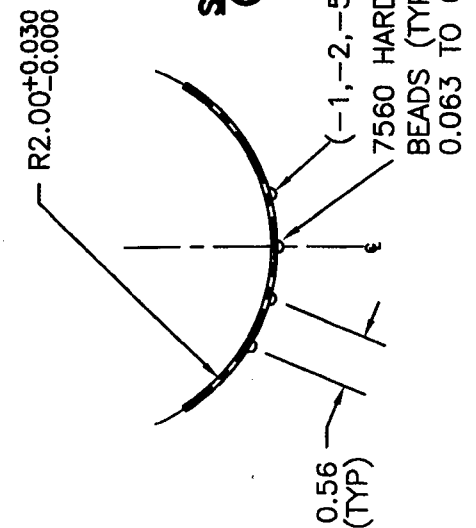


DETAIL D
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

SECTION E-E
(SCALE 1:2)



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